

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004234**Date Inspected:** 06-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** NA**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Heavy shop #1

The QA Inspector performed visual and magnetic particle inspections of the following tower components prior to green tag release:

SSDI-23M: Performed visual inspection of two undercut weld repair areas that had been identified by day shift QA personnel. Areas observed appear to comply with project specifications.

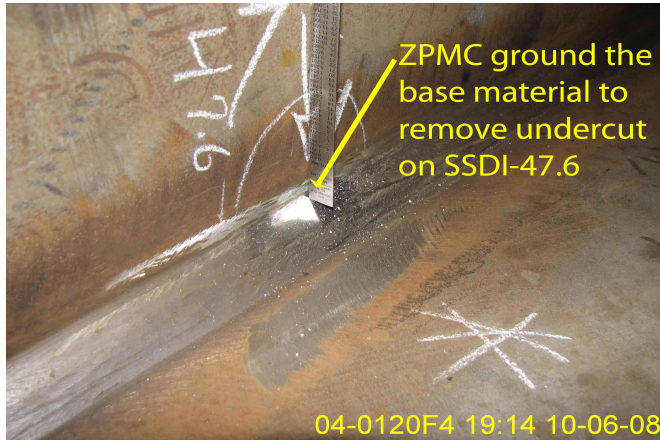
SSDI-38M: All accessible welds were visually inspected and the QA Inspector observed three welds had undercut that were greater than 1mm below flush. After the areas were weld repaired the welds appear to comply with project specifications. The QA Inspector performed random magnetic particle inspections of approximately 10 % length of half of the welds on SSDI-38M. The QA Inspector informed QA Inspector Mr. Mike Hasler that additional welds require magnetic particle inspections prior to QA green tag release.

SSDI- 47.6: All accessible welds were visually inspected and the QA Inspector observed two welds had portions where the undercut was greater than 1mm below flush. After the areas were weld repaired the welds appear to

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comply with project specifications.



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

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| Inspected By: | Dawson,Paul | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
